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Serial Number : 10/690,808  
Amendment in Response to Office Action of 07/18/2005

#### AMENDMENTS TO CLAIMS

What is claimed as being new and desired to be protected by LETTERS PATENT of the United States is as follows:

1. (Currently Amended) A pick and place system for safely and efficiently accepting workpieces with flanges to be cold forged and for delivering them to a die comprising, in combination:

a vertical wall having an upper portion with a fixed support plate and a lower die face for a cold forging system;

a transfer housing and an air cylinder coupled to the housing with cylindrical rods horizontally secured to the support plate and with the housing and air cylinder laterally reciprocable upon the rod;

a pair of fingers having lower free ends with facing tips formed with recesses for receiving and supporting a flange of a workpiece, the fingers having an upper follower, the follower being vertically reciprocable to move the tips between an expanded orientation for releasing a workpiece and a contracted orientation for retaining a workpiece; and

~~a rotatable main shaft with a cam operable with an air valve with a driver button whereby the cam will periodically contact the button, the button and valve adapted to periodically actuate the air cylinder through lines for reciprocating the transfer~~

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housing between a workpiece accepting orientation remote from the support plate wherein the fingers are contracted and a workpiece delivering orientation adjacent to the support plate whereat the fingers are expanded.

2. (Original) A pick and place system comprising:  
a wall having a fixed support plate and a die face;  
a transfer housing and an air cylinder with a cylindrical rod horizontally secured to the support plate and with the housing and air cylinder laterally reciprocable upon the rod; and  
fingers having lower free ends for receiving a workpiece, the fingers having an upper follower, the follower being vertically reciprocable to move the fingers between an expanded orientation and a contracted orientation.

3. (Currently Amended) The system as set forth in claim 2 and further including ~~a rotatable main shaft with a cam operable with an air valve with a driver button whereby the cam will periodically contact the button, the button and valve adapted to periodically actuate the air cylinder through lines for~~ reciprocating the transfer housing between a workpiece accepting orientation remote from the support plate wherein the fingers are contracted and a workpiece delivering orientation adjacent to the support plate whereat the fingers are expanded.